

Date: Friday, 7/20/2007 10:21:28 AM
User: Kim Johnston

Process Sheet

Dart Aerospace Ltd.

31

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PILOT/CO-PILOT STEP, RH (FOLDING)
Job Number : 33696
Estimate Number : 10824
P.O. Number : N/A Part Number : D412630032
This Issue : 7/20/2007 S.O. No. : N/A Drawing Number : D412-630 REV.J, P17-19
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : JK
Previous Run : 33463 Material : N/A
Written By : Due Date : 8/2/2007 Qty: 3, Um: Each
Checked & Approved By :
Comment : EST. REV. A 05.11.21 NEW ISSUE EC
EST. REV. B 05.12.19 updated pick list EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D412-630 bluefile & type labels per PPP412-630-031 CHG001

2.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.17

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

3.0 D3463042 Step Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3463-042	Step weldment	B 33493

4.0 D3443043 Strut Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-043	Strut ass'y	B 29672 x 3mx

5.0 D3443041 Strut Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-041	Strut ass'y	B 33698 x 2mx, B 25517 x 1mx,

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Seq. #:

Machine Or Operation:

Description :

6.0

D34439

PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description
2	D3443-9	Pin

Batch

B 30208

MF

7.0

AN4CH3

SS Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description
2	AN4CH3	BOLT
A/R	MS20995c41e	Lockwire

Batch

m103248

m101537

MF

8.0

AN4C14

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description
1	AN4C14	BOLT

Batch

m103248

MF

9.0

D34547

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description
2	D3454-7	Bushing

Batch

B 30225 x B mx, B 33701 x 3 mx.

MF

10.0

AN3104

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description
1	AN310-4	Nut

Batch

m103641 x 2mx m105059 x 1mx

MF 07-08-02

W/O:		WORK ORDER CHANGES					
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Job Number: 33696

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

MS24665227

COTTER PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS24665-227 COTTER PIN

Batch m102073

MF

12.0

D34551

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3455-1 Spacer

Batch B 28171

MF

13.0

D34651

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3465-1 Washer

Batch B 30308 ~~X1~~ MX, B 33706 ~~X2~~ MX

MF

14.0

AN3107

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN310-7 Nut

Batch m103286

MF

15.0

MS24665302

Cotter Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS24665-302 COTTER PIN

Batch m16941

MF. 07-08-02

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

****ensure tension to retract step is 11 to 18 lbs ****

Test fit on aircraft in Eng. lab.

For 07/08/02 (X30)H

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

18.0

D34541

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description
1 D3454-1 Bushing

Batch

33730 - 50

19.0

D34543

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description
2 D3454-3 Bushing

Batch

30223 - 50

20.0

D34545

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description
2 D3454-5 Bushing

Batch

30224 - 50

21.0

D34551

Spacer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number Description
6 D3455-1 Spacer

Batch

B2817L 7/5/2 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D34553

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3455-3	Spacer	1328172 - ✓ SP

23.0

D3462042

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3462-042	Bracket ass'y	33703 - ✓ SP

24.0

AN3104

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN310-4	Nut	1105057 - ✓ SP

25.0

AN3105

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN310-5	Nut	1102073 - ✓ SP

26.0

AN3C5A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
3	AN3-C5A	Bolt	1100186 - ✓ SP

27.0

AN44C12

eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
7/8/2			50

W/O:		WORK ORDER CHANGES					
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Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

1

AN44-C12

Eyebolt

28.0

AN4C15

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

AN4C15

BOLT

M103248 ✓

SD

29.0

AN5C11

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

AN5C11

BOLT

M103248 ✓

SD

30.0

AN5C15

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

AN5C15

BOLT

M105160 ✓

SD

31.0

AN960C10

WASHER



Comment: Qty.: 7.0000 EACH(s)/Unit Total : 21.0000 EACH(s)

Pick:

Qty

Part Number

Description

Batch

7

AN960C10

Washer

M101064 ✓

SD

32.0

AN960C516

WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

AN960C516

Washer

M17697 ✓

7/8/2 SD

W/O:		WORK ORDER CHANGES					
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Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

MS210433

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick:

Qty Part Number Description Batch
3 MS21043-3 Nut

M1041995 ✓ SP

34.0

MS24665227

COTTER PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 MS24665-227 COTTER PIN

M102073 ✓ SP

35.0

MS24665229

COTTER PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 MS24665-229 COTTER PIN

M19086 ✓ SP

36.0

NAS1515H5

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 NAS1515H5 Washer

M105135 ✓

7/8/1 SP

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Er 07/08/02 (+3/kits)

7/8/02

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-031

Location:

PPP Rev:

07/8/3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/08/03

QA: N/C Closed: _____ Date: _____

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Job Number: 33696

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

39.0

QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

207/08/03

Job Completion



Final 07-08-02.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

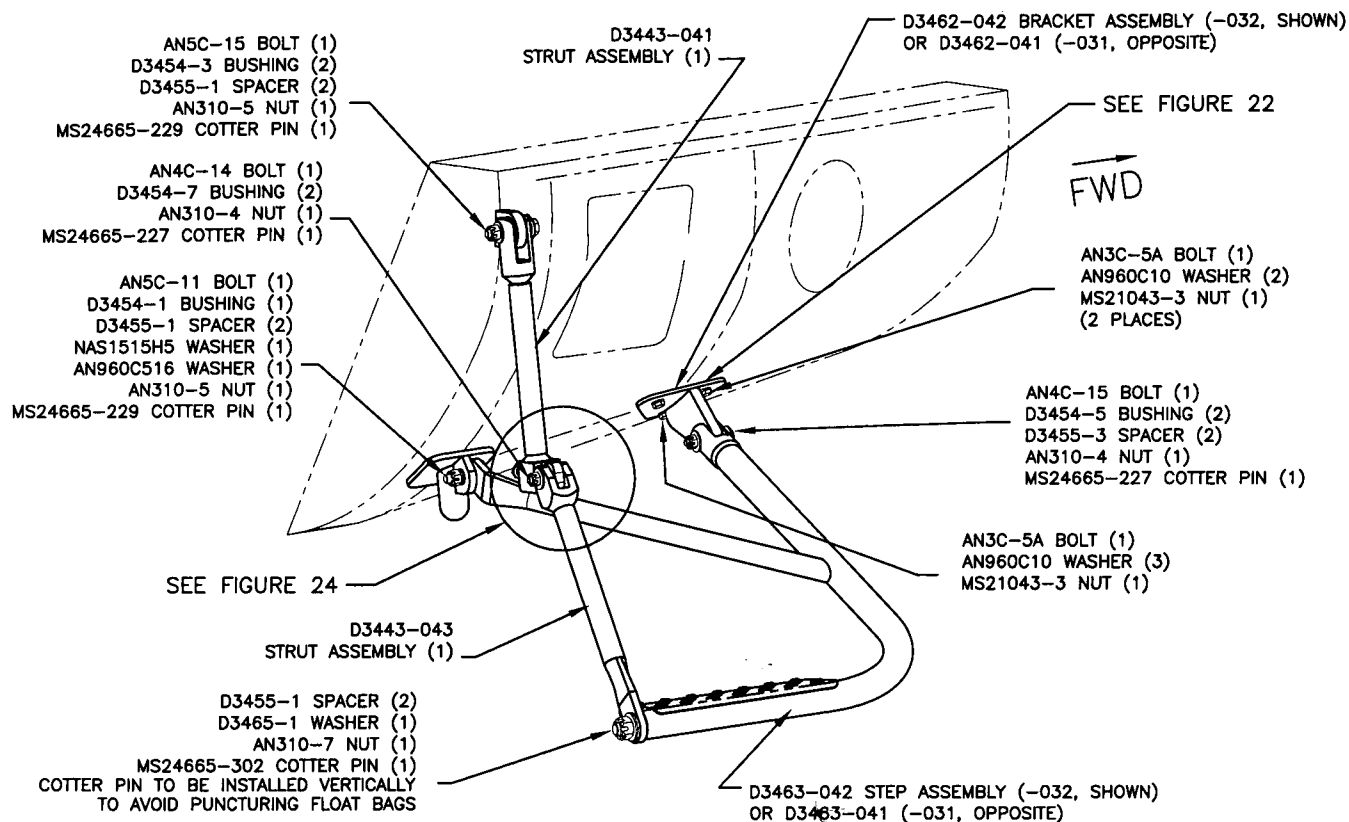
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

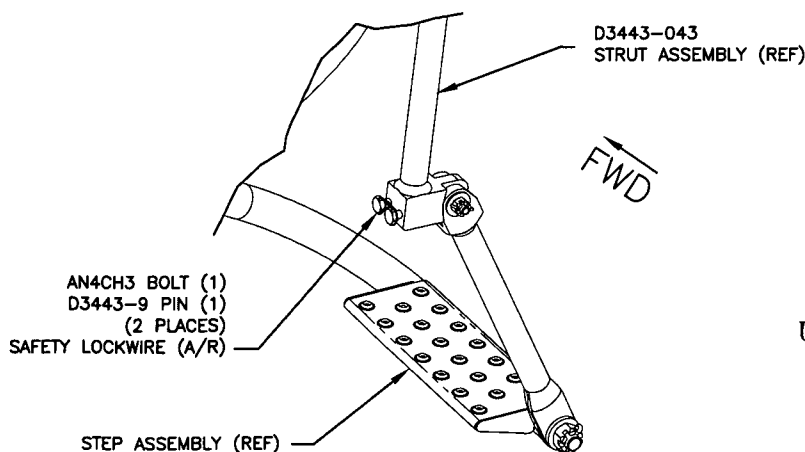
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NOTE: Date & initial all entries

**FIGURE 23 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)**



**FIGURE 24 – Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)**



SHOP COPY
RETURN TO
ENGINEERING
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WITHOUT NOTICE
WORK ORDER
NO. 33696